

Date: Tuesday, 19/08/2008 4:03:42 PM  
 User: Julie Lecocq

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : GAS SPRING ASSEMBLY                             |
| <b>Job Number</b> : 41421                              |   |
| <b>Estimate Number</b> : 10181                         |   |
| <b>P.O. Number</b> :                                   | <b>Part Number</b> : D2153  |
| <b>This Issue</b> : 19/08/2008 <b>S.O. No.</b> :       | <b>Drawing Number</b> : D2153 REV. A1                                 |
| <b>Prsht Rev.</b> : NC                                 | <b>Project Number</b> : N/A   |
| <b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS | <b>Drawing Revision</b> : A1  |
| <b>Previous Run</b> : 39540                            | <b>Material</b> :   |
| <b>Written By</b> :                                    | <b>Due Date</b> : 10/09/2008 <b>Qty:</b> 36 <b>Um:</b> 20 <b>Each</b> |
| <b>Checked &amp; Approved By</b> : <u>JLD 08.8.19</u>  |   |
| <b>Comment</b> : Est: E 02.07.08 Re-format KJ/RF       |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |    |            |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|

**Comment:** PURCHASINGIssue P/O: 7001

C 208/08/21

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

\*\*Note: Do not ship by air\*\*\*\*

Allow an extra 7 to 10 business days for shipping\*\*

Material release note is required

|     |        |           |
|-----|--------|-----------|
| 2.0 | D2153P | Door Prop |
|-----|--------|-----------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
 GAS SPRING ASSEMBLY

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** DIMENSIONAL CHECK

Inspect Test Spring is 10lb

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 41421

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Locknut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

4/177

*Handwritten signature*

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

M/08672

*Handwritten signature*

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

106939

17X

50X

M102939 (5X) 7/08/12

M109111

6/8/13

(36)

(15)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

7/08/12 (36)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5080915 (430) counter

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57435

6/8/15 (36)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 41421

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-09-15*

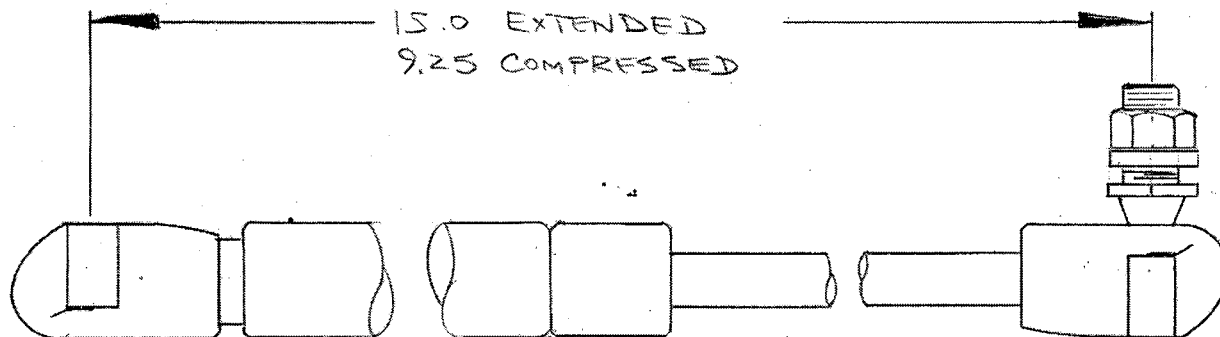
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



SL-13-10 SPRING (SPRING LIFT CORP)

SL69-BS STUD (SPRING LIFT CORP)

AN 960-516 WASHER

5/16-18 UNF SELF LOCKING NUT  
D3015-3



**RELEASED**  
96/07/16

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 11421

|    |                       |   |  |               |      |  |          |             |
|----|-----------------------|---|--|---------------|------|--|----------|-------------|
| AI | REVISION              | RIVET CODE SHALL BE PER NAS 523               |  | PART NO.      | ITEM | DESCRIPTION                                      | MATERIAL | SPEC/VENDOR |
| AI | DRAWN                 | BASIC CODE                                    |  | CONTRACT NO.  |      | DART DART AERO ACCESSORIES INC. VANCOUVER CANADA |          |             |
| AI | APPROVED              | O/A DASH NO. P-HEAD NEAR SIDE F-HEAD FAR SIDE |  | DRAWN HATTON  |      | DATE 07.28.92                                    |          |             |
| AI | DESCRIPTION OF CHANGE | O-DOUBLE DASH NO OF SHEETS C-COUNTERSINK      |  | DESIGN HATTON |      | TITLE GAS SPRING ASSEMBLY                        |          |             |
| AI |                       | BASIC CODES 84-M520410AD 86-M520410AD         |  | STRESS        |      | CODE   |          | REV A       |
| AI |                       | CHECKED SEA 01-07 7/7/92                      |  | CLIENT        |      | DWG NO DZ153                                     |          |             |
| AI |                       | REPORT ALL DISCREPANCIES - DO NOT SCALE       |  |               |      | SCALE 1:1  |          | SHT 1 OF 1  |

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS - UNLESS OTHERWISE SPECIFIED

GENERAL  
1. DIMENSIONS ARE IN INCHES  
2. SURFACE ROUGHNESS 125  
3. REMOVE SHARP EDGES .015 MAX  
4. THREADS PER UNF - 5-2842  
5. HOLES PER AND 10087

LIMITS  
1. TOLERANCES - .004 & .030  
2. ANGLES .010  
3. PARALLELISM .0025  
4. ECCENTRICITY .005 MAX  
5. STRAIGHTEN ABOUT ALL D/C CENTRE LINE .005

# attwood®

## SWIVL-EZE

TELEPHONE: 616-897-2290

BILL TO: DART AERO LTD.  
REQ: 08/28/08

ATTWOOD / SWIVL-EZE

1016 NORTH MONROE  
LOWELL

MI 49331-0260

DART AERO LTD.  
1270 ABERDEEN STREET

HAWKESBURY

ON

K6A 1K7

CRTS: 1 PD#: P000007001

WGT: 14 DATE: 08/28/08

SPUR: 9

LABEL NO:  
4786690001

---ROUTING GUIDE INFO---

---SHIPPED---  
CRTS QTY

LOCATN UM PART# / UPC

DESCRIPTION / SKU

ORDER  
LINE QTY

WGT

1 36

Z09211 EA SL13-10-1

GS SPRNG 15" EXTC 10# BL

1

36 ✓ 12

MP 50

~~Z10321 EA SL69-BS-1~~

~~10MM BALL STUD W/THRD~~

2

50 ✓ 2

*006908*



# DART

## Purchase Order

|                                     |           |
|-------------------------------------|-----------|
| Date<br>Aug 21, 2008                | Page<br>1 |
| Purchase Order Number<br>PO00007001 |           |

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**RECEIVED**  
AUG 21 2008

### Vendor Address:

Attwood  
1016 North Monroe St  
Lowell, MI 49331  
USA  
Phone (616) 897-2370  
Fax (616) 897-8358

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

| Reference | Contact | Vendor Number | PO Date      | Terms | Ship Via | Expected Arrival |
|-----------|---------|---------------|--------------|-------|----------|------------------|
|           |         | VU-ATT001     | Aug 21, 2008 | N30   | Fedex    | Sep 03, 2008     |

| Qty. Ordered        | Item Number | Description   | Expected Arrival | Drop-Ship | Unit Cost                           | UOM  | Extended Price |
|---------------------|-------------|---|------------------|-----------|-------------------------------------|------|----------------|
| 36.0000             | D2153P      | Door Prop B41421<br>Comments: AS PER DWG D2153 REV. A1<br>P/N: SL13-10 (10LBS) GAS SPRING | 9/3/2008         | No        | 4.110000                            | Each | 147.96         |
| 50.0000             | SL69BS      | Ball Stud   | 9/3/2008         | No        | 1.000000                            | Each | 50.00          |
| Tax Summary:        |             |   |                  |           | Less: included tax                  |      | 0.00           |
| Entered By: CLAVOIE |             |   |                  |           | Subtotal                            |      | 197.96         |
| Approved By:        |             |   |                  |           | Total tax                           |      | 0.00           |
|                     |             |   |                  |           | Total purchase order in USD Dollars |      | 197.96         |